

**What is claimed is:**Sub D<sup>1</sup>  
7

1. A pan liner system having a contoured or customed shaped liner that can be disposed over an interior surface of a pan for forming an improved barrier between said pan and food disposed therein, said pan liner system comprising:

a pan, said pan comprising:

a bottom panel;

one or more side walls extending upwardly from said bottom panel, said one or more side walls each having a top edge, said top edge defining a pan top opening;

a pan liner having a contour fit disposed within said pan to cover an interior surface of said pan, said contour fit pan liner comprising:

a contoured bottom edge forming a closed bottom end disposed over said pan proximate said bottom panel;

one or more flexible side walls extending upwardly from said bottom end, said side walls generally covering an interior surface of said pan;

an open top end, said top end extending upwardly beyond said pan top opening and said liner open top end being folded over said top edge of said one or more side walls of said pan; and

wherein said pan liner does not have dog ears formed proximate said closed bottom end.

Sub D<sup>2</sup>  
7

2. The pan liner system of claim 1, wherein said contoured bottom edge further comprises a flat bottom edge and two contoured edges, wherein said flat bottom edge is joined and merged at each end with one of said contoured edges, and said contoured edges extend outward and upward from said flat bottom edge and are joined and merged at an opposite end with a side wall edge.

3. The pan liner system of claim 2, wherein each of said contoured edges comprises a substantially straight tapered edge.

4. The pan liner system of claim 3, wherein each of said tapered edges is formed having a predetermined angle from a plane defined by said flat bottom edge, wherein said angle is predetermined based on said shape and size of said pan.

5. The pan liner system of claim 2, wherein each of said tapered edges forms an angle of about 40 to about 55 degrees with a plane defined by said flat bottom edge.

6. The pan liner system of claim 2, wherein each of said contoured edges comprises a curved edge.

7. The pan liner system of claim 6, wherein each of said curved edges is formed having a radius that is predetermined based on said shape and size of said pan.

8. The pan liner system of claim 1, wherein said pan liner body is preformed having a generally tubule shape body having a closed bottom end and an open top end.

9. The pan liner system of claim 1, wherein said contour fit pan liner is removable disposed within said pan.

10. The pan liner system of claim 1, wherein said pan liner is a high temperature plastic material.

11. The pan liner system of claim 10, wherein said pan liner is a high temperature nylon resin material

12. The pan liner retention system of claim 10, wherein said high temperature liner can withstand a temperature of about 400°F.

13. A contour fit pan liner for forming a barrier between a food service pan and food disposed therein, said food service pan having a food receptacle defined by a bottom panel, one or more side wall extending upwardly from an outer edge of said bottom panel, and a top opening defined by a top edge of said pan side walls, said contour fit pan liner comprising:

a closed bottom end;

one or more side walls extending upwardly from said closed bottom end;

an open top end defined by a top edge of said side walls; and

wherein said closed bottom end comprises a contoured bottom edge constructed to conform to a shape and a size of said pan.

14. The contour fit pan liner of claim 13, wherein said contoured bottom edge further comprises a flat bottom edge and one or more contoured edges, said flat bottom edge being joined and merged at each of two ends with said contoured edges, said contoured edges extending outward and upward and being joined and merged with said side walls.

15. The contour fit pan liner of claim 14, wherein said contoured edges comprise substantially straight tapered edges shaped to correspond to a shape and a size of said pan.

16. The pan crown of claim 15, wherein said contoured edge of said liner extends outward and upward from said liner flat bottom edge at an angle that substantially corresponds to an angle formed by an intersection of said pan bottom panel and said pan side walls.

17. The contour fit pan liner of claim 14, wherein said contoured edges comprise curved edges shaped to correspond to a shape and a size of said pan.

18. The pan crown of claim 17, wherein said contoured edge of said liner extends outward and upward from said liner flat bottom edge forming a rounded edge having a radius of curvature that substantially corresponds to said intersection of said pan bottom panel and said pan side walls.

19. The contour fit pan liner of claim 13, wherein said contoured bottom edge is formed without any dog ears proximate said bottom edge and said side walls.

20. A method for making a pan liner having a contour fit for forming an improved barrier over an interior surface of a food service pan comprising:

providing two overlying sheets of plastic liner material;

forming a substantially tubular shaped liner defining a food holding vessel between said overlying sheets of liner material by;

closing a bottom end, said closed bottom end comprising a flat bottom edge and two contoured edges extending outward and upward from said flat bottom end, wherein each of said contoured edges closes off a dog ear portion of said tubular shaped liner;

closing one or more side walls formed by said overlying sheets of liner material extending upward from said closed bottom end, said side wall being closed along one or more side wall edges extending upward from each of said contoured edges; and

forming an open top end defined by a top edge of said side walls of said liner.

21. The method according to claim 20, further comprising removing said dog ears formed by said contoured edges on a side of said sealed contoured edge opposite said tubular shaped liner.

22. The method according to claim 20, further comprising forming a perforation along each of said sealed contoured edges on said dog ear side of said sealed contoured edge.

23. The method according to claim 20, further comprising forming each of said contoured edges having a tapered edge that extends outward and upward from said flat bottom edge at a predetermined angle from a plane defined by said flat bottom edge, said angle being predetermined based on a shape and a size of said pan.

24. The method according to claim 20, further comprising forming each of said contoured edges having a curved edge that extends outward and upward from said flat bottom edge and a predetermined radius of curvature, said radius of curvature being predetermined based on a shape and a size of said pan.

25. The method according to claim 20, wherein said sealing is accomplished using one of heat or thermo-sealing, impulse-sealing, sonic-sealing, and RF-sealing.

26. A method for making a pan liner having a contour fit for forming an improved barrier over an interior surface of a food service pan comprising:

providing a flat sheet of plastic liner material;

folding said liner material in half along a longitudinal length thereby forming a closed flat bottom edge along a folded edge; and

forming a substantially tubular shaped body defining a food holding vessel by sealing said liner material along one or more contoured edges and one or more side wall edges, each of said contoured edges extending outward and upward from said closed flat bottom edge and joining and merging with one of said side wall edges, said side wall sealed edges extending upward to an open top end.

27. A method for fitting a contour fit pan liner over an interior surface of a food service pan comprising:

providing a pan having a bottom panel, one or more side walls extending upwardly from said bottom panel, and a top opening defined by a top edge of said side walls;

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